

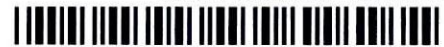


Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D2734

Job Sheet 181840



Part No: D2734

Job Qty: 30 ea

Part Name: Step End Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/9/18

Job Tracking No:

Due Date: 9/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP: D 01.06.08 Removed Deburr EC IPP Rev:E 07-12-18 RevC as per dwg ECN1048 DD  
verified by:EC

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                    |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation | 30 Ea  | 9/14/18    | 9/14/18  | 0.00      | 0.00    | Start Up Waterjet     |           | DE 18/08/18 |
| 100   | Waterjet           | 30 pcs | 9/14/18    | 9/14/18  | 0.00      | 0.42    | Waterjet1             |           | DE 18/08/18 |
| 120   | QC                 | 30 pcs | 9/14/18    | 9/14/18  | 0.00      | 0.00    | QC8                   |           | AUG 16 2018 |
| 130   | Small Fab          | 30 pcs | 9/14/18    | 9/14/18  | 0.01      | 0.30    | Small Fab-2           |           | DE 18/08/18 |
| 140   | QC                 | 30 pcs | 9/14/18    | 9/14/18  | 0.00      | 0.00    | QC5                   |           | DE 18/08/18 |
| 150   | Packaging          | 30 pcs | 9/14/18    | 9/14/18  | 0.00      | 0.00    | Packaging3            |           | DE 18/08/18 |
| 160   | QC21-SA            | 30 Ea  | 9/14/18    | 9/14/18  | 0.00      | 0.00    | QC21                  |           | SEP 17 2018 |

Part Op 100 - 1-Cut as per Dwg D 2734

Descriptions: 130 - Form as per drawing D2734

150 - \*\*\* STOCK IN STEP CELL \*\*\*

### Job BOM

| Part / Item   | Component Name      | Quantity             | Operation             | Container |
|---------------|---------------------|----------------------|-----------------------|-----------|
| M5052H32S.063 | 5052-H32 .063 Sheet | 1.8750 sf (.0625 ea) | 90-Start up Operation | S082502   |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M5052H32S.063  | 2        | 36        | 0         |

### Part Specifications

| Spec No | Description | Target/Tolerance    | Limits         | Type | Special Comments |
|---------|-------------|---------------------|----------------|------|------------------|
| 1       | End Plate   | 2.900inches ± 0.030 | 2.930<br>2.870 |      |                  |
| 2       | End Plate   | 3.040inches ± 0.030 | 3.070<br>3.010 |      |                  |
| 3       | End Plate   | 0.063inches ± 0.010 | 0.073<br>0.053 |      |                  |

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                          | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>_____ |                          | <b>AGAINST DEPARTMENT/PROCESS</b> <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:10%;">Skid-tube</td><td><input type="checkbox"/></td> <td style="width:10%;">Cross tube</td><td><input type="checkbox"/></td> <td style="width:10%;">Water Jet</td><td><input type="checkbox"/></td> <td style="width:10%;">Engineering</td><td><input type="checkbox"/></td> </tr> <tr> <td>Machining</td><td><input type="checkbox"/></td> <td>Small Fab</td><td><input type="checkbox"/></td> <td>Prod. Eng. Coord.</td><td><input type="checkbox"/></td> <td>Quality</td><td><input type="checkbox"/></td> </tr> <tr> <td>Thermoforming</td><td><input type="checkbox"/></td> <td>Finishing</td><td><input type="checkbox"/></td> <td>Rec/Store/Packaging</td><td><input type="checkbox"/></td> <td>Other</td><td><input type="checkbox"/></td> </tr> <tr> <td>Large Fab</td><td><input type="checkbox"/></td> <td>Composite</td><td><input type="checkbox"/></td> <td>Supplier</td><td><input type="checkbox"/></td> <td></td><td></td> </tr> </table> |                          |                       |                          |                      |                          |                    |                          | Skid-tube | <input type="checkbox"/> | Cross tube       | <input type="checkbox"/> | Water Jet        | <input type="checkbox"/> | Engineering | <input type="checkbox"/> | Machining | <input type="checkbox"/> | Small Fab | <input type="checkbox"/> | Prod. Eng. Coord. | <input type="checkbox"/> | Quality            | <input type="checkbox"/> | Thermoforming | <input type="checkbox"/> | Finishing    | <input type="checkbox"/> | Rec/Store/Packaging   | <input type="checkbox"/> | Other | <input type="checkbox"/> | Large Fab            | <input type="checkbox"/> | Composite     | <input type="checkbox"/> | Supplier | <input type="checkbox"/> |        |                          |      |                          |                |                          |              |                          |          |                          |                        |                          |                    |                          |                   |                          |          |                          |                 |                          |       |                          |                 |                          |            |                          |                    |                          |                  |                          |          |                          |         |                          |         |                          |                  |                          |         |                          |            |                          |            |                          |        |                          |     |                          |                     |                          |                    |                          |              |                          |         |                          |            |                          |                     |                          |               |                          |                       |                          |                  |                          |                  |                          |                       |                          |  |  |  |  |  |  |               |                          |          |                          |  |  |  |  |  |  |               |  |
| Skid-tube                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| Machining                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <input type="checkbox"/> | Small Fab                                                          | <input type="checkbox"/> | Prod. 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Coord.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | <input type="checkbox"/> | Quality               | <input type="checkbox"/> |                      |                          |                    |                          |           |                          |                  |                          |                  |                          |             |                          |           |                          |           |                          |                   |                          |                    |                          |               |                          |              |                          |                       |                          |       |                          |                      |                          |               |                          |          |                          |        |                          |      |                          |                |                          |              |                          |          |                          |                        |                          |                    |                          |                   |                          |          |                          |                 |                          |       |                          |                 |                          |            |                          |                    |                          |                  |                          |          |                          |         |                          |         |                          |                  |                          |         |                          |            |                          |            |                          |        |                          |     |                          |                     |                          |                    |                          |              |                          |         |                          |            |                          |                     |                          |               |                          |                       |                          |                  |                          |                  |                          |                       |                          |  |  |  |  |  |  |               |                          |          |                          |  |  |  |  |  |  |               |  |
| Thermoforming                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          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| Large Fab                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| Description :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          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   |  |
| <div style="position: relative; height: 200px;"> <div style="position: absolute; top: 0; right: 0; font-size: 0.8em;">           Dart Aerospace Ltd.<br/>           1270 Aberdeen Street<br/>           Cambridge, ON M6A 1K7<br/>           TEL: 1 813 832-5200<br/>           Email: sales@dartaero.com<br/>           www.dartaerospace.com         </div> <div style="position: absolute; bottom: 0; left: 0; transform: rotate(-45deg); font-weight: bold; font-size: 1.2em;">           DART<br/>AEROSPACE         </div> <div style="position: absolute; bottom: 10%; left: 10%;">           Container No: S102822<br/>           Part: D2734<br/>           Job No: 181840<br/>           Serial No/Batch: S102822<br/>           Revision:<br/>           Inspector:<br/>           Exp Date:<br/>           Instructions: Various STC's         </div> <div style="position: absolute; right: 10%; top: 50%; transform: rotate(90deg); font-size: 0.8em;">           Date: 08/18/18         </div> </div>                    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| <b>Root Cause</b> <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:10%;">Environment</td><td><input type="checkbox"/></td> <td style="width:10%;">No Re-verification</td><td><input type="checkbox"/></td> <td style="width:10%;">Pressure</td><td><input type="checkbox"/></td> <td style="width:10%;">Power Loss/Surge</td><td><input type="checkbox"/></td> <td style="width:10%;">Positioned Wrong</td><td><input type="checkbox"/></td> </tr> <tr> <td>Design</td><td><input type="checkbox"/></td> <td>Operator</td><td><input type="checkbox"/></td> <td>Bending</td><td><input type="checkbox"/></td> <td>Polio/Program</td><td><input type="checkbox"/></td> <td>Outside Dimensions</td><td><input type="checkbox"/></td> </tr> <tr> <td>Doc/Data</td><td><input type="checkbox"/></td> <td>Offset/Setup</td><td><input type="checkbox"/></td> <td>Centre Not Concentric</td><td><input type="checkbox"/></td> <td>Grain</td><td><input type="checkbox"/></td> <td>Over/Under tolerance</td><td><input type="checkbox"/></td> </tr> <tr> <td>Equip/Tooling</td><td><input type="checkbox"/></td> <td>Supplier</td><td><input type="checkbox"/></td> <td>Cracks</td><td><input type="checkbox"/></td> <td>Weld</td><td><input type="checkbox"/></td> <td>Part Incorrect</td><td><input type="checkbox"/></td> </tr> <tr> <td>Handling/Pre</td><td><input type="checkbox"/></td> <td>Training</td><td><input type="checkbox"/></td> <td>Crimp/Kink/Ripple/Wave</td><td><input type="checkbox"/></td> <td>Wrong Stock Pulled</td><td><input type="checkbox"/></td> <td>Part Lost/Missing</td><td><input type="checkbox"/></td> </tr> <tr> <td>Material</td><td><input type="checkbox"/></td> <td>Use for Testing</td><td><input type="checkbox"/></td> <td>Cuffs</td><td><input type="checkbox"/></td> <td>Out of Sequence</td><td><input type="checkbox"/></td> <td>Part Moved</td><td><input type="checkbox"/></td> </tr> <tr> <td>Internal Transport</td><td><input type="checkbox"/></td> <td>Poor Information</td><td><input type="checkbox"/></td> <td>Crushing</td><td><input type="checkbox"/></td> <td>Off-set</td><td><input type="checkbox"/></td> <td>Drawing</td><td><input type="checkbox"/></td> </tr> <tr> <td>Tribal Knowledge</td><td><input type="checkbox"/></td> <td>Rushing</td><td><input type="checkbox"/></td> <td>Heat Treat</td><td><input type="checkbox"/></td> <td>Mislabeled</td><td><input type="checkbox"/></td> <td>Finish</td><td><input type="checkbox"/></td> </tr> <tr> <td>LOA</td><td><input type="checkbox"/></td> <td>Product Improvement</td><td><input type="checkbox"/></td> <td>Wave/Twist in Tube</td><td><input type="checkbox"/></td> <td>Fit/Function</td><td><input type="checkbox"/></td> <td>Misread</td><td><input type="checkbox"/></td> </tr> <tr> <td>Substation</td><td><input type="checkbox"/></td> <td>Process Improvement</td><td><input type="checkbox"/></td> <td>Marks/Chatter</td><td><input type="checkbox"/></td> <td>Misaligned/off center</td><td><input type="checkbox"/></td> <td>Turning Sequence</td><td><input type="checkbox"/></td> </tr> <tr> <td>Past Expiry Date</td><td><input type="checkbox"/></td> <td>Manufacturing Process</td><td><input type="checkbox"/></td> <td></td><td></td> <td></td><td></td> <td></td><td></td> </tr> <tr> <td>Misidentified</td><td><input type="checkbox"/></td> <td>Past Due</td><td><input type="checkbox"/></td> <td></td><td></td> <td></td><td></td> <td></td><td></td> </tr> </table> |                          |                                                                    |                          |                                                                                                                                                                                                                                                                                                                                                                                                                              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type="checkbox"/> | Bending   | <input type="checkbox"/> | Polio/Program     | <input type="checkbox"/> | Outside Dimensions | <input type="checkbox"/> | Doc/Data      | <input type="checkbox"/> | Offset/Setup | <input type="checkbox"/> | Centre Not Concentric | <input type="checkbox"/> | Grain | <input type="checkbox"/> | Over/Under tolerance | <input type="checkbox"/> | Equip/Tooling | <input type="checkbox"/> | Supplier | <input type="checkbox"/> | Cracks | <input type="checkbox"/> | Weld | <input type="checkbox"/> | Part Incorrect | <input type="checkbox"/> | Handling/Pre | <input type="checkbox"/> | Training | <input type="checkbox"/> | Crimp/Kink/Ripple/Wave | <input type="checkbox"/> | Wrong Stock Pulled | <input type="checkbox"/> | Part Lost/Missing | <input type="checkbox"/> | Material | <input type="checkbox"/> | Use for Testing | <input type="checkbox"/> | Cuffs | <input type="checkbox"/> | Out of Sequence | <input type="checkbox"/> | Part Moved | <input type="checkbox"/> | Internal Transport | <input type="checkbox"/> | Poor Information | <input type="checkbox"/> | Crushing | <input type="checkbox"/> | Off-set | <input type="checkbox"/> | Drawing | <input type="checkbox"/> | Tribal Knowledge | <input type="checkbox"/> | Rushing | <input type="checkbox"/> | Heat Treat | <input type="checkbox"/> | Mislabeled | <input type="checkbox"/> | Finish | <input type="checkbox"/> | LOA | <input type="checkbox"/> | Product Improvement | <input type="checkbox"/> | Wave/Twist in Tube | <input type="checkbox"/> | Fit/Function | <input type="checkbox"/> | Misread | <input type="checkbox"/> | Substation | <input type="checkbox"/> | Process Improvement | <input type="checkbox"/> | Marks/Chatter | <input type="checkbox"/> | Misaligned/off center | <input type="checkbox"/> | Turning Sequence | <input type="checkbox"/> | Past Expiry Date | <input type="checkbox"/> | Manufacturing Process | <input type="checkbox"/> |  |  |  |  |  |  | Misidentified | <input type="checkbox"/> | Past Due | <input type="checkbox"/> |  |  |  |  |  |  | OTHER : _____ |  |
| Environment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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| Design                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Doc/Data                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| Equip/Tooling                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          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| Handling/Pre                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           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| Material                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| Internal Transport                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     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| Tribal Knowledge                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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| LOA                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    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| Substation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             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| Past Expiry Date                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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| Misidentified                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          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                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                          |                       |                          |                      |                          |                    |                          |           |                          |                  |                          |                  |                          |             |                          |           |                          |           |                          |                   |                          |                    |                          |               |                          |              |                          |                       |                          |       |                          |                      |                          |               |                          |          |                          |        |                          |      |                          |                |                          |              |                          |          |                          |                        |                          |                    |                          |                   |                          |          |                          |                 |                          |       |                          |                 |                          |            |                          |                    |                          |                  | 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